

5/30

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>23799</b>
<b>Description: Outer Fwd Saddle</b>	<b>Part Number:</b>	<b>D5951</b>
<b>Drawing: D5951 Rev. A</b>	<b>Qty:</b>	<b>12</b>

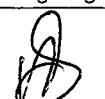
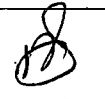
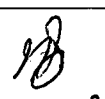
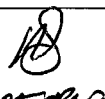

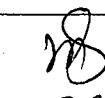
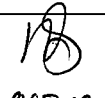
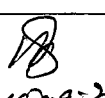
Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Issue Work Order <i>Dwg not required</i>	<i>HA</i>	05.07.14	12
2	STORES	Issue material from stock: D6101-013 (7075-T7351) Cut Size 2.50" x 10.10" X 8.25" (Grain along 10.10") Batch: <b>23798</b>	<i>P/En</i>	05/09/25	12
3	HAAS	Setup W/O No. <i>/</i> Setup Inspection last completed <i>/</i> by <i>/</i>	<i>/</i>	N/A	<i>/</i>
4	HAAS	Machine as per folio D5951 <b>Ensure Batch Number is entered 23799</b>	<i>P/En</i>	05/09/25	12
5	HAAS	Deburr and Tumble	<i>P/En</i>	05/09/25	12
6	QC	Inspect Level 1 Fill Out Inspection Sheet	<i>P/En</i>	05/09/25	12
7	QC	Inspect Level 8 Audit Inspection Sheet	<i>SD</i>	05.09.26	12
8	METAL	Acid etch and alodine as per QSI 005 4.1	<i>ML</i>	05.10.25	12
9	FINISHING	Powder Coat White (Ref. 4.3.5.1) as per Dart QSI 005 4.3	<i>ML</i>	05.10.25	12
10	QC	Inspect Level 3	<i>CD</i>	05/10/26	12
11	STORES	Pack in foam, identify and stock	<i>PU</i>	05/10/26	12
12	EXPEDITING	Close Work Order Cost / Part : <b>230.68</b> <i>Sub 05/10/27</i> <b>(12)</b>	<i>PD</i>	05/10/27	12

Rev	Date	Change	Revised By	Approved
A	97.03.05			
B	99.04.19	Re-format	DM	
C	00.06.22	Removed P/O for powder coat	EC	
D	02.02.06	Added D part # and inspect level 21	NG	

RELEASED

02/02/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05/09/22	4	one part scrap. wall thickness on bore's 0.040 thin to thin come out of Jig		Jig has been repaired Scrap & replace	En 05/09/22	 0509-22	 0509-22	 0509-22
05/09/22	24	Part scrap (1) from previous problem with set up (before this one)	 0509-22	scrap + destroy	En 05/09/22	 0509-22	 0509-22	 0509-22

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:  Date: 05/10/27

NOTE: Date &amp; initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>23799</b>
<b>Description: Outer Fwd Saddle</b>	<b>Part Number:</b>	<b>D5951</b>
<b>Inspection Dwg: D5951 Rev. A</b>		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D5951 Rev. A and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	✓	✓	✓	✓		
B	1.745	1.755		1.750	1.747	1.748	1.748		
C	5.245	5.255		5.250	5.252	5.248	5.248		
D	6.995	7.005		6.998	6.999	7.001	6.999		
E	5.745	5.755		5.750	5.747	5.746	5.746		
F	4.745	4.755		4.750	4.748	4.746	4.746		
G	0.313	0.318	DT8686	✓	✓	✓	✓		
H	1.522	1.532		1.526	1.525	1.525	1.527		
I	3.048	3.058		3.054	3.051	3.052	3.051		
J	4.575	4.585		4.579	4.579	4.577	4.577		
K	0.313	0.318	DT8686	✓	✓	✓	✓		
L	0.240	0.260		0.250	0.259	0.253	0.253		
M	0.490	0.510		0.498	0.501	0.502	0.503		
N	0.240	0.260		0.252	0.257	0.251	0.251		
O	7.990	8.010		8.001	8.002	8.001	8.002		
P	0.240	0.260		0.253	0.257	0.254	0.251		
Q	0.307	0.312		0.310	0.311	0.310	0.311		
R	0.760	0.765		0.760	0.760	0.760	0.760		
S	0.490	0.510		0.500	0.499	0.496	0.496		
T	1.375	1.395		1.390	1.383	1.386	1.385		
U	2.000	2.020		2.008	2.003	2.007	2.005		
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	EP
Date:	05/09/23

Audited by:	SA
Date:	05.09.26

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686	KJ/RF	

**RELEASED**  
03.06.18

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>23799</b>
<b>Description: Outer Fwd Saddle</b>	<b>Part Number:</b>	<b>D5951</b>
<b>Inspection Dwg: D5951 Rev. A</b>		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D5951 Rev. A and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	✓	✓	✓	✓		
B	1.745	1.755		1.747	1.750	1.749	1.749		
C	5.245	5.255		5.247	5.250	5.250	5.250		
D	6.995	7.005		6.999	6.999	6.999	6.998		
E	5.745	5.755		5.746	5.749	5.750	5.749		
F	4.745	4.755		4.746	4.749	4.749	4.749		
G	0.313	0.318	DT8686	✓	✓	✓	✓		
H	1.522	1.532		1.528	1.527	1.528	1.528		
I	3.048	3.058		3.050	3.056	3.053	3.057		
J	4.575	4.585		4.575	4.582	4.581	4.580		
K	0.313	0.318	DT8686	✓	✓	✓	✓		
L	0.240	0.260		0.252	0.256	0.258	0.257		
M	0.490	0.510		0.501	0.506	0.505	0.505		
N	0.240	0.260		0.256	0.259	0.258	0.258		
O	7.990	8.010		8.001	8.000	8.001	8.001		
P	0.240	0.260		0.251	0.255	0.256	0.254		
Q	0.307	0.312		0.310	0.311	0.311	0.311		
R	0.760	0.765		0.760	0.760	0.760	0.760		
S	0.490	0.510		0.495	0.499	0.500	0.501		
T	1.375	1.395		1.385	1.386	1.388	1.384		
U	2.000	2.020		2.005	2.006	2.008	2.004		
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	<i>Ed. J. J.</i>
Date:	05/09/15

Audited by:	<i>SD</i>
Date:	05.09.26

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686	KJ/RF <i>RF</i>	<i>#</i>

**RELEASED**  
03.06.18 *RF*

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 23799
<b>Description:</b> Outer Fwd Saddle	<b>Part Number:</b> D5951
<b>Inspection Dwg:</b> D5951 Rev. A	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D5951 Rev. A and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	✓	✓	✓	✓		
B	1.745	1.755		1.749	1.750	1.750	1.749		
C	5.245	5.255		5.250	5.250	5.249	5.249		
D	6.995	7.005		6.998	6.999	6.999	6.999		
E	5.745	5.755		5.749	5.749	5.750	5.750		
F	4.745	4.755		4.750	4.749	4.750	4.749		
G	0.313	0.318	DT8686	✓	✓	✓	✓		
H	1.522	1.532		1.529	1.531	1.528	1.528		
I	3.048	3.058		3.051	3.051	3.052	3.050		
J	4.575	4.585		4.581	4.580	4.580	4.581		
K	0.313	0.318	DT8686	✓	✓	✓	✓		
L	0.240	0.260		.258	.257	.257	.256		
M	0.490	0.510		.501	.500	.502	.501		
N	0.240	0.260		.257	.257	.258	.257		
O	7.990	8.010		8.001	8.001	8.000	8.001		
P	0.240	0.260		.255	.256	.256	.257		
Q	0.307	0.312		.311	.311	.311	.311		
R	0.760	0.765		.760	.760	.760	.760		
S	0.490	0.510		.502	.502	.500	.502		
T	1.375	1.395		1.385	1.390	1.390	1.389		
U	2.000	2.020		2.005	2.009	2.010	2.009		
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <i>[Signature]</i>	Audited by: <i>SD</i>
Date: 05/09/25	Date: 05.09.26

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686	KJ/RF <i>[Signature]</i>	<i>[Signature]</i>

**RELEASED**  
03.06.18 *[Signature]*

# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Jul 14, 2005  
01:41 pm

Work Order No : 0023799  
Project Name : D5951  
Project For : WK530  
Work Order Type : Main  
Main WO Number :  
House Part Number : D5951  
Description : Saddle  
Manufactured : Yes  
Amount Req'd : 12  
Amount Done : 0  
Start Date : 07-14-05  
Est Finish Date : 07-30-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
  
Order Entry No :  
OE Value : 0.00  
  
Est Mark Up : 0.000%  
Actual Mark Up : 0.000%  
  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Mark up	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00